

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014375**Date Inspected:** 09-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Chi Chen and Li Yand**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Trial Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) Trial Assembly Areas

Incident Report for Segment 7CW to 7DW (Deck Panel Extension)

This Quality Assurance (QA) Inspector wrote an Incident Report for flatness of Transverse Splice Segment weld at Side Panel Cross Beam side for Segment 7CW to Segment 7DW between Panel Point (PP) 55 and PP 56 for more comprehensive details please refer the Incident Report # 04-0120F4_TL-15_B278_05-09-2010_Side Panel Flatness at Transverse Splice Weld_7CW to 7DW between PP 55 to PP 56 Dated May 09, 2010. Please refer the pictures for more comprehensive details.

Segment 8AE to 8BE (Skin Flatness) Joint Survey

This QA Inspector performed Joint Inspection with ABF Survey Team for the Skin Flatness between Segment 8AE to 8BE (Shop Segment Splice) between Panel Point (PP) 64 and PP 65.

Cross Beam side at B1 and B2 locations and Bike Path side at B3 and B4 Locations at weld connecting Bottom

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Panel to Side Panel with 5000mm String line for overall deformation and 600mm and 630 mm Straight Edge for localized deformation and

Cross Beam side at T1 location and Bike Path side T2 Location at weld connecting Deck Panel to Edge Panel with 5000mm String line for overall deformation and 600mm and 630 mm Straight Edge for localized deformation. The measured and recorded readings were submitted to the Lead and Engineer for review.

Segment 8BE to 8CE (Skin Flatness) Joint Survey

This QA Inspector performed Joint Inspection with ABF Survey Team for the Skin Flatness between Segment 8BE to 8CE (Shop Segment Splice) between Panel Point (PP) 67 and PP 68.

Cross Beam side at B1 and B2 locations and Bike Path side at B3 and B4 Locations at weld connecting Bottom Panel to Side Panel with 5000mm String line for overall deformation and 600mm and 630 mm Straight Edge for localized deformation and

Cross Beam side at T1 location and Bike Path side T2 Location at weld connecting Deck Panel to Edge Panel with 5000mm String line for overall deformation and 600mm and 630 mm Straight Edge for localized deformation.

The measured and recorded readings were submitted to the Lead and Engineer for review.

Segment 8CW

This QA inspector observed, ZPMC qualified welding personnel identified as 058087 perform Shielded Metal Arc Welding (SMAW) for weld connecting Deck Panel to Edge Panel Counter Weight side, weld joint identified as CA053-004. The Critical Welding Repair Report (CWRR) was B-CWR1405. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1.

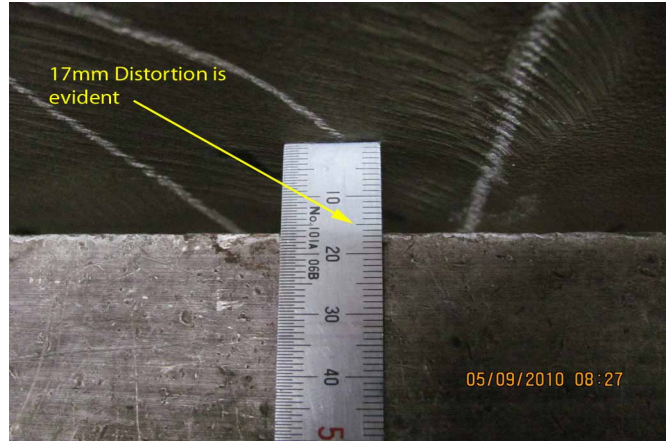
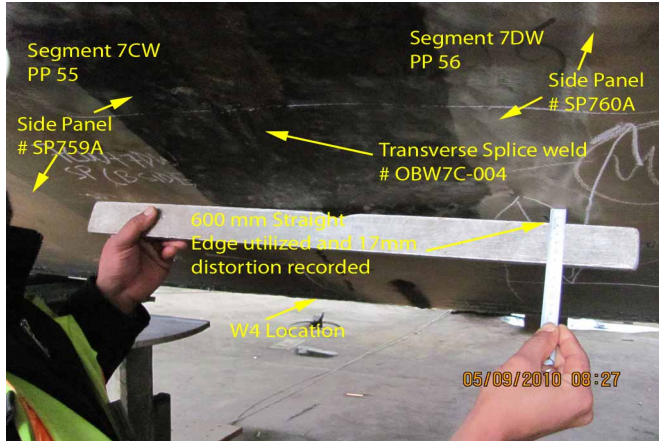
Segment 7BE

This QA inspector observed, ZPMC qualified welding personnel identified as 066258 perform Shielded Metal Arc Welding (SMAW) for weld connecting Deck Panel to Edge Panel Bike Path side, weld joint identified as CA042-004. The Critical Welding Repair Report (CWRR) was B-CWR1378. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric T Sang 1500-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Math,Manjunath

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer